



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

ADP

D3319-1
Job Sheet 175959



Part No: D3319-1

Job Qty: 12 ea
13

DAS
21
9-89

Part Name: Forward Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

Due Date: 5/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC IPP Rev:C Now on Waterjet 06-10-26 JLM IPP REV:D
17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	5/19/18	5/19/18	0.00	0.00	Start Up Waterjet		OK 18/04/13
100	Waterjet	12 pcs	5/19/18	5/19/18	0.00	1.25	Waterjet1		OK 18/04/13
110	QC	12 pcs	5/19/18	5/19/18	0.00	0.00	QC2 Waterjet-2		OK 18/04/13
120	QC	12 pcs	5/19/18	5/19/18	0.00	0.00	QC8-2		OK
140	Brake NC	12 pcs	5/19/18	5/19/18	0.07	0.87	Brake NC 1		OK
150	QC	12 pcs	5/19/18	5/19/18	0.00	0.00	QC5		OK
160	Autoweld 1	12 pcs	5/19/18	5/19/18	0.00	3.08	Automated welding		OK
170	QC	12 pcs	5/19/18	5/19/18	0.00	0.00	QC10		OK
180	QC	12 pcs	5/19/18	5/19/18	0.00	0.00	QC5		OK
190	SprayPaint	12 pcs	5/21/18	5/21/18	0.00	0.28	Spray Paint		10/05/2018 JMD
200	QC	12 pcs	5/21/18	5/21/18	0.00	0.00	QC3		OK
210	Packaging	12 pcs	5/21/18	5/21/18	0.00	0.00	Packaging3-1	5/603	DAS MAY 14 2018
220	QC21-SA	12 Ea	5/21/18	5/21/18	0.00	0.00	QC21		OK 18/05/18

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary 9-89

Descriptions: 140 - 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: _____ 2- Form flat on press using DT8776 block

160 - 8259 HARDCOAT B: 5024335

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.
BATCH: 138842

210 - Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	7.5360 sf (.628 ea)	90-Start up Operation	5007416 5042197

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S18GA	8	192	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	4.980inches ± 0.030	5.010		

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ c/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	MRB (QSI042) Approval			
Description Work Order Deviation					
DART Aerospace Ltd. 1210 Aberdeen Street, Unit K64-1K7 Newbury, ON K6A 1K7 Canada TEL: 1-813-632-5200 FAX: 1-813-632-5201 EMail: sales@dartaero.com www.dartaero.com Date: 04/13/18 Container No: S061006 Part: D3319-1 Job No: 175959 Serial No/ Batch: S061006 Revision: D Inspector:					

			4.950
2	Wearplate	1.600inches $\pm$ 0.010	1.610 1.590
3	Wearplate	2.660inches $\pm$ 0.010	2.670 2.650
4	Wearplate	3.190inches $\pm$ 0.010	3.200 3.180
5	Wearplate	3.563inches $\pm$ 0.010	3.573 3.553
6	Wearplate	4.710inches $\pm$ 0.030	4.740 4.680
7	Wearplate	0.600inches $\pm$ 0.030	0.630 0.570
8	Wearplate	10.576inches $\pm$ 0.010	10.586 10.566
9	Wearplate	11.942inches $\pm$ 0.010	11.952 11.932
10	Wearplate	18.090inches $\pm$ 0.030	18.120 18.060
11	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315
12	Wearplate	0.546inches $\pm$ 0.010	0.556 0.536
13	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315
14	Wearplate	0.670inches $\pm$ 0.010	0.680 0.660
15	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189
16	Wearplate	3.815inches $\pm$ 0.010	3.825 3.805
17	Wearplate	16.100inches $\pm$ 0.010	16.110 16.090

Plex 4/12/18 12:55 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					